

3/16/20

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2432-3
Job Sheet 199293



Part No: D2432-3

Job Qty: 8 pcs

Part Name: 206 (24") Bearpaw



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/16/19

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 8/30/19

Type: SOLD

Description:

Note: DWG REV H IPP REV:A AS PER REV G 12-07-24 JLM VERIFIED BY:DD IPP REV:B 12.10.17 AS PER DWG
REV.H DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
90	Purchasing	8 pcs		8/30/19	0.00	0.00	Purchasing - 1	AUG 21 2019
							Purchasing - 2	
							Purchasing - 3	
100	Packaging 2-1 - Receive - B4B	8 pcs		8/30/19	0.00	0.00	Packaging 2 - 1 - B4B	AUG 21 2019
							Packaging 2 - 2 - B4B	
							Packaging 2 - 3 - B4B	
							Packaging 2 - 5 - B4B	
							Packaging 2 - 4 - B4B	
							Packaging 2 - 6 - B4B	
							Packaging 2 - 7 - B4B	
							Packaging 2 - 8 - B4B	
							Packaging 2 - 9 - B4B	
							Packaging 2 - 10 - B4B	
							Packaging 2 - 11 - B4B	
							Packaging 2 - 12 - B4B	
							Packaging 2 - 13 - B4B	
							Packaging 2 - 14 - B4B	
							Packaging 2 - 15 - B4B	
							Packaging 2 - 16 - B4B	
							Packaging 2 - 17 - B4B	
							Packaging 2 - 18 - B4B	
							Packaging 2 - 19 - B4B	
							Packaging 2 - 20 - B4B	
							Packaging 2 - 21 - B4B	
							Packaging 2 - 22 - B4B	
							Packaging 2 - 23 - B4B	
							Packaging 2 - 24 - B4B	
							Packaging 2 - 25 - B4B	
							Packaging 2 - 26 - B4B	
							Packaging 2 - 27 - B4B	



Container No: S207794

Part: D2432-3

Job No: 199293

Serial No/Batch: S207794

Inspector:

Exp Date:

Instructions: Various STC's

Date: 08/21/19

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaero.com

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8/16/2019

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					Packaging 2 - 28 - B4B	
					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
110	QC 6	8 pcs	8/30/19	0.00 0.00	QC 6 - 9	
					QC 6 - 68	DAS 81
					QC 6 - 61	9-89
					QC 6 - 40	
					QC 6 - 81	DAS 52
130	HAAS 4 Axis - B4B	8 pcs	8/30/19	1.00 13.14	HAAS - 1 - B4B	19/10/27
					HAAS - 2 - B4B	9-89
					HAAS - 3 - B4B	
					HAAS - 4 - B4B	
140	QC 2	8 pcs	8/30/19	0.00 0.00	QC 2 - 1	
					QC 2 - 12	
					QC 2 - 14	
					QC 2 - 17	
					QC 2 - 19	
					QC 2 - 2	
					QC 2 - 20	
					QC 2 - 22	
					QC 2 - 23	
					QC 2 - 25	
					QC 2 - 32	
					QC 2 - 33	
					QC 2 - 35	
					QC 2 - 39	
					QC 2 - 4	
					QC 2 - 40	
					QC 2 - 44	
					QC 2 - 45	
					QC 2 - 48	
					QC 2 - 49	
					QC 2 - 50	
					QC 2 - 51	
					QC 2 - 52	DAS 52
					QC 2 - 57	19/10/26
					QC 2 - 62	9-89
					QC 2 - 63	
					QC 2 - 8	
					QC 2 - 66	
					QC 2 - 64	
					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
150	QC 8	8 pcs	8/30/19	0.00 0.00	QC 8 - 12	
					QC 8 - 14	On 19/11/01
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	

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[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
160	Packaging 3-1 - Stock - B4B	8 pcs	8/30/19	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B
					Packaging 3 - 28 - B4B
					Packaging 3 - 29 - B4B
					Packaging 3 - 30 - B4B
					Packaging 3 - 31 - B4B
					Packaging 3 - 32 - B4B
					Packaging 3 - 33 - B4B
					Packaging 3 - 34 - B4B
					Packaging 3 - 35 - B4B
					Packaging 3 - 36 - B4B
170	QC 21 - SA	8 pcs	8/30/19	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 53

DAS
28
9-89DAS
21 NOV 14 2019
9-89

Part Op 90 - 1-Issue PO; _____ 2-Cut blanks as per D2432_NEST7 file.
 Descriptions: 100 - Receive & Inspect for Damage & Mat'l Certs.

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8/16/2019

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

- 110 - QC6- All purchased or subcontracted products
- 130 - (HAAS CNC vertical machine #1) 1-Inspect material for defects or damage prior to machining 2-Machine as per Folio B122 and Dwg D2432 Identify as D2432-3
- 140 - (QC2- Inspect parts off machine FA/FAIB)
- 150 - (QC8- Inspect parts - second check)
- 160 - (Identify as per dwg & Stock Location: _____)
- 170 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2432P	Bearpaw 19" X 24"	8 Ea (1 ea)	90-Purchasing	
MCHAW/BK		29,6 SF (3,75f each)	DAS 35	S20 7793 S154152

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Purchasing	D2432P	8	0	0

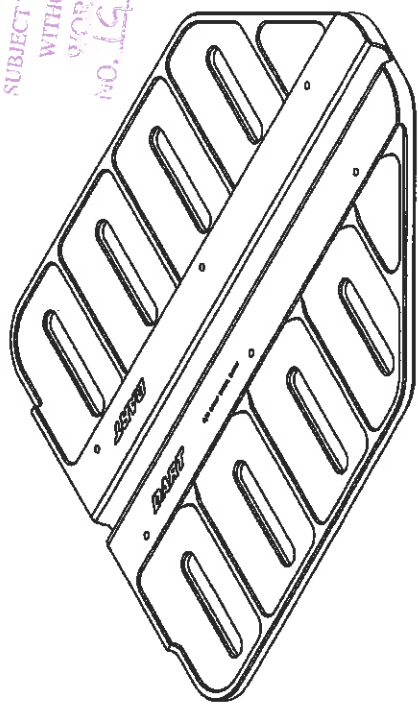
Part Specifications

Specifications could not be found.

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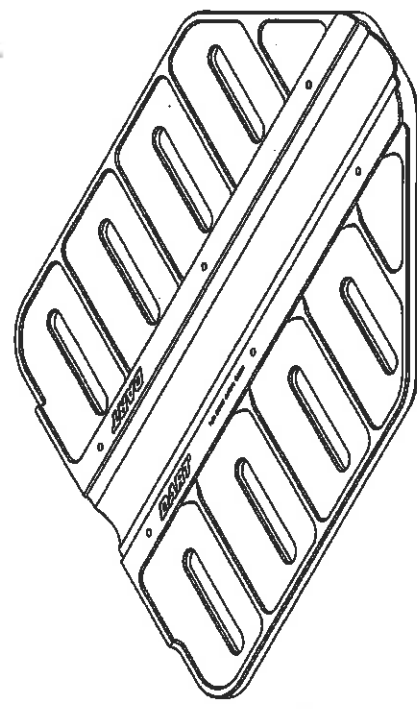
1 2 3 4 5 6 7 8

STAMP COPY
RETURN TO
ENGINEER
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 159293
1908-16



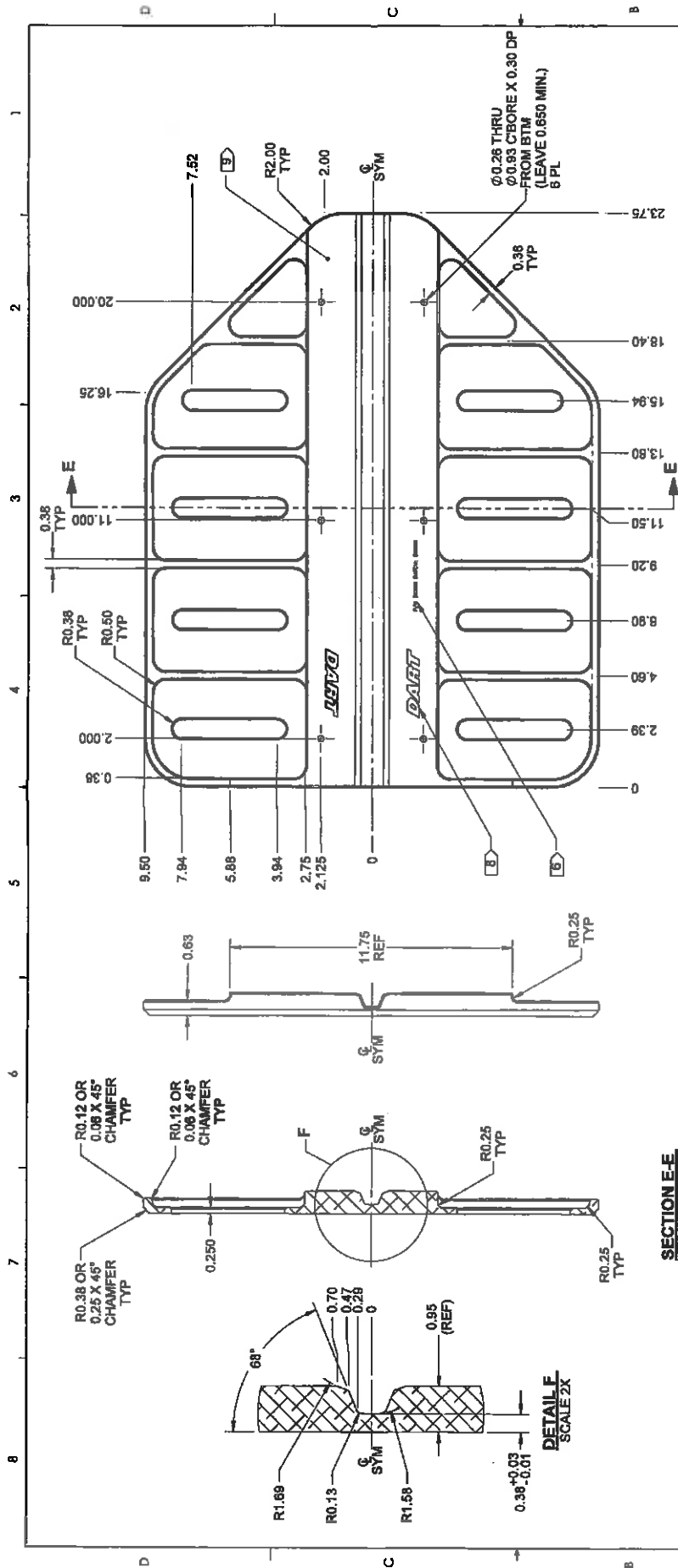
D2432-3 BEARPAW

RELEASED
N 2012-10-15



D2432F BEARPAW

H	RIB HEIGHTS CHANGED TO CONDITION OF REV. F. SEE REV. F FOR DETAILS.	AP	12.09.24
G	UPDATE DRAWING FORMAT, REMOVED D2432B, ADD D2432F, ADDED DIMENSION (SEE D11-4)	AP	12.05.02
F	CHANGE C'BORE, ADD B AND F PIN	-	86.06.12
E	CHANGE C'BORE DEPTH, BORE RADIUS	-	97.02.27
D	MOVE SLOT	-	86.08.04
C	CHANGE BORE AND C'BORE DEPTH	-	86.03.28
B	RE-DESIGN	-	86.01.24
A	NEW ISSUE	-	85.10.31
REV.	DESCRIPTION	BY	DATE
DESIGN	LE		
DRAWN	AP		
CHECKED	ALS		
MFG. APPR.	BY		
APPROVED	NO		
DATE	12.09.24		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWING NO. D2432			
REV. H SHEET 1 OF 3			
TITLE BEARPAW			
SCALE NTS			
CONFIDENTIALITY NOTICE: THIS DRAWING IS THE PROPERTY OF DART AEROSPACE LTD. IT IS TO BE USED FOR THE PURPOSES FOR WHICH IT WAS DESIGNED AND NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM, WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.			



D2432-3 BEARPAW

REVISION
2012-10-16

DESIGN	LE	AP	DATE	12.09.24
DRAWN	AP			
CHECKED	AL			
MFG. APPR.	AL			
APPROVED	AL			
DE APPR.	AL			
TITLE	BEARPAW			
DRAWING NO.	D2432			
REV. H	SHEET 3 OF 3			
SCALE	NYS			
DATE	12.09.24			

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

- NOTES:**
- 1) MATERIAL: UHMW BLACK TIVAR 1000 VIRGIN MATERIAL, 1.000 THICK MACHINED TO 0.950 (REF DART SPEC. MUH-MWB10)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: ENGRAVE PART NUMBER "D2432-3" AND BATCH NUMBER "BXXXXX" IN ACCORDANCE WITH QSI 044 METHOD 8.3
 - 7) WEIGHT: 6.25 lbs
 - 8) ENGRAVE DART LOGO TO MAX DEPTH OF 0.012
 - 9) APPLY 0.06 X 45° CHAMFER TO ALL EDGES ON SIDE SHOWN UNLESS OTHERWISE INDICATED
 - 10) PROFILE PER DRAWING FILE "D2432-3-REV.H.STP"



Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____		DISPOSITION		DEPARTMENT/PROCESS											
		Rework Scrap Use-as-is		Skid-tube Machining Large Fab		Cross tube Small Fab Finishing		Eng. (Non-AW) Prod. Eng. Coord. Rec/Store/Packaging		Engineering Water Jet Supplier Quality					
Date :	Sequence #:	QTY Affected :		MRB (QS1042)											
Description Work Order Deviation				Disposition											
Completed By				Lead hand / Supervisor											
QC / QA Coordinator															
Root Cause				FAULT CATEGORY											
				Pressure/Forced Bending Crushing Cracks Crimp/Kink/Ripple/Wave/Twist Marks/Chatter Mislabeled				Contamination Misaligned/off center BOM/Route Broken/Damage/Defect Incomplete/Unclear Instructions Drill Holes Fit/Function				Power Loss/Surge Folio/Program Grain Direction Weld Wrong Stock Pulled Out of Sequence Off-set/Set-up			
Operator				Positioned Wrong Outside Tolerance Drawing Finish Part Lost/Missing Misread											
Manufacturing Process															
Equip/Tooling															
Handling/Preservation															
Material															
Product Improvement															
Process Improvement															
Human Factors															
Other/Details:															

DART AEROSPACE LTD		Work Order: 199293
Description: 206 Bearpaw		Part Number: D2432-3
Inspection Dwg: D2432	Rev: H	Page 1 of 1

INSPECTION SHEET

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	Ø0.260	+0.006/-0.001	Ø 0.260	✓		G.P.	
B	0.93	+/-0.030	0.930	✓		Ver	
C	0.300	+0.030/-0.000	0.310	✓		D.I.G.	
D	0.06 x 45°	+/-0.030 x +/-0.5°	0.20 x 45°	✓		Ver	
E	2.000	+/-0.010	2.000	✓		Ver	
F	11.000	+/-0.010	11.000	✓		Ver	CNC-02
G	20.000	+/-0.010	20.000	✓		Ver	CNC-02
H	4.250	+/-0.005	4.280	✓		Ver	Calculated
I	5.50	+/-0.030	5.50	✓		Ver	Calculated
J	19.00	+/-0.030	19.00	✓		TAPE	Calculated
K	23.75	+/-0.030	23.75	✓		TAPE	
L	0.25 x 45°	+/-0.030 x +/-0.5°	0.25 x 45°	✓		Ver	
M	0.95	+/-0.030	0.960	✓		Ver	
N	0.63	+/-0.030	0.635	✓		Ver	
O	0.250	+/-0.010	0.255	✓		Ver	
P	0.380	+0.030/-0.010	0.385	✓		Ver	Calculated
Q	1.4	+/-0.030	1.40	✓		Ver	
R	0.38	+/-0.030	0.38	✓		Ver	
S	R0.25	+/-0.030	R.0.250	✓		R.G.	1
T							
U							
V							
W							
X							
Y							
Z							
AA							
AB							

Measured by: DAS 52	Checked by: [Signature]	QC Inspector:
Date: 9-89 19/10/26	Date: 19/10/01	Date:

Engineering Approval: (If necessary)	Date:
--	--------------

Rev	Date	Change	Revised by	Approved
A	16.06.23	New Issue	KJ [Signature]	[Signature]



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB044289



Supplier: ACI002-VC
Acier Duval Steel
5888 Country Road 17
Plantagenet
ON
K0B 1L0 Canada
Phone: 613-673-5474
Fax: 613-673-4576

PO No: POHB044289

PO Date: 8/19/19

Due Date: 8/26/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

E-MAILED
309-08-20

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Pymt Terms:

Net 30

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Supplier Part No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	199292	D2521P		Individual Bearpaw as per Dwg D2521_Blank File	Firmed	-	8/26/19	20 Ea	0 Ea	20 Ea	\$57.77/Ea	\$1,155.40
						20	X	AUG 21 2019				
2	199291	D3075-1P		Bearpaw (Foot Print Only), as per Dwg D3075_blanknest file	Firmed	-	8/26/19	10 Ea	0 Ea	10 Ea	\$19.97/Ea	\$199.70
						10	X	AUG 21 2019				
3	199290	D3529-1P		Bearpaw as per Dwg F3529-1_4x8 file	Firmed	-	8/26/19	18 Ea	0 Ea	18 Ea	\$23.37/Ea	\$420.66
						18	X	AUG 21 2019				
4	199293	D2432P		Bearpaw 19" X 24"; as per DWG D2432_nest7 file	Firmed	-	8/26/19	8 Ea	0 Ea	8 Ea	\$35.26/Ea	\$282.08
						8	X	AUG 21 2019				
Grand Total:												\$2,057.84

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance - NOT SUPPLIED.

A041 quality management system
A042 dart notification by supplier
A043 retension of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 8/20/19 11:20 AM Dart.Guerin.Kimberley

A.D.S.

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T: 513-673-4574

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5888 County Rd. 17

Plantagenet, ON.

K0B 1L0

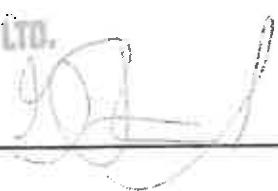
Packing Slip:

9024

Aug 21, 2019

1 of 1

Sold to:	Ship to:
Dart Aerospace 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Dart Aerospace 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No: PCHS011020 ✓	Sold By:
Shipped By:	Ship date:
Tracking No:	

Item No	Quantity	Description
Water jet cutting	20 ✓	Waterjet cutting only, customer material UHMW 1" black: Individual Bearpaw as per Dwg D2521_Blank file, Job 199292 Part#D2521P ✓
Water jet cutting	10 ✓	Waterjet cutting only, customer material UHMW 1" black: Bearpaw (Foot Print Only) as per Dwg D3075_Markings file, Job 199291, Part #D3075-1P ✓
Water jet cutting	19 ✓	Waterjet cutting only, customer material UHMW 1" black: Bearpaw as per Dwg F3529_4x9 file, Job 199290, ✓ Part#D3529-1P ✓
Water jet Cutting	8 ✓	Waterjet cutting only, customer material UHMW 1" black: Bearpaw 15" x 24" as per DWG.D2432_part2 file, Job 199293, ✓ Part#D2432P ✓
RECEIVED AUG 21 2019 DART AEROSPACE LTD. 		
Comment: ADS Industries - Facebook & Instagram		